



Dart Aerospace Ltd.
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D4881-041
Job Sheet 171892



Part No: D4881-041

Job Qty: 1 ea

Part Name: 206A/B AFT Leg Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/9/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 1,2 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV:C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/15/18	0.00	0.00	Start Up Small Fab-4		FF
110	Small Fab	1 pcs		2/15/18	0.34	0.71	Small Fab-8		DA FP
120	QC	1 pcs		2/15/18	0.00	0.00	QC5		38
130	Small Fab	1 pcs		2/16/18	0.00	0.71	Small Fab-8		9-89 DAS FF
140	QC	1 pcs		2/16/18	0.00	0.00	QC5		DAS 38
180	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-2		21 9-89 S2
190	QC21-SA	1 Ea		2/16/18	0.00	0.00	QC21		9-89 FEB 14 2018

ST516

Part Op 110 - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-1 AND D4885-3. DRILL OUT EACH HOLES
Descriptions: USING A PILOTTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9973
AS PER DWG.

130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER
DWG USE DT9974 A/R BATCH: 138708 2- LASER ENGRAVE ASSY PART# AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	1 Ea (1 ea)	90-Start up Operation	F162833
D4885-1	End Fitting	1 Ea (1 ea)	90-Start up Operation	F124011
D4885-3	End Fitting	1 Ea (1 ea)	90-Start up Operation	5003356
HL32PB5-12	Hi-Lok Pin	4 Ea (4 ea)	90-Start up Operation	5008240
HL86-5	Hi-Lok Collar	4 pcs (4 ea)	90-Start up Operation	PT1129022

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4881-1	1	1	0
	D4885-1	1	1	0
	D4885-3	1	8	0
	HL32PB5-12	4	34	0
	HL86-5	4	107	0

Part Specifications

Specifications could not be found.

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ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

ATION	AGAINST DEPARTMENT/PROCESS				
Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
Approved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

QTY Effective :

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

FAULT CATEGORY

☐ rced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Concentric	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ /Ripple/Wave	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Contamination	☐ Out of Sequence	☐ Part Moved
	☐ Countersink	☐ Off-set	☐ Drawing
	☐ Cut Too Short	☐ Misabeled	☐ Finish
	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

Start up Operation 02/12/18
Job No: 171892

PART NO: D4881-041
Original Serial #: S041443
Revision:
Operation:
Change No:

206A/B AFT Leg Assembly, LH

Material ☐	Use for Testing ☐
Internal Transport ☐	Poor Information ☐
Tribal Knowledge ☐	Rushing ☐
LOA ☐	Product Improvement ☐
Substation ☐	Process Improvement ☐
Past Expiry Date ☐	Manufacturing Process ☐
Misidentified ☐	Past Due ☐

OTHER :